

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave.St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 1.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-018514**Date Inspected:** 03-Dec-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 630**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1500**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Job Site**CWI Name:** Listed below.**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** S.A.S. Components**Summary of Items Observed:**

The Quality Assurance Inspector (QAI), Scott Croff, was present at the Self Anchored Span (SAS) job site to observe the scheduled fabrication and welding of components for the SFOBB project. The following observations were made:

1) OBG Deck Hole Welding

The QAI made observations of welding of the OBG deck hole patches on the East and West lines of the S.A.S. OBG structure. The QAI noted that these patches are being placed and welded into the deck access / ventilation holes and lifting lug holes. The QAI observed Earl Espinoza, ID 5824, fitting and welding lifting lug patches at PP31 E3 #2 and #4. The QAI noted that the Quality Control (QC) Inspector Pat Swain is monitoring the fitting and welding. The QAI noted that ABF-WPS-D15-1050A is being used for this welding. The QAI randomly measured the welding parameters and noted that they appeared to be conforming to the WPS requirements. This work was in progress at the end of the shift. See the attached photo.

The QAI made observations of fitting and welding on deck access hole patch at PP61.5-E2SE. The QAI observed Mick Chan, ID 9265, using SMAW to make the tack and root welds as the patch was being fit up. The QAI noted that the QC Inspector Steve McConnell is monitoring this work. During the process of fitting, the QAI noted that the complete joint penetration (CJP) weld has apparent gaps which exceed the WPS requirements. The QC Inspector informed the QAI that weld build up will be performed after all the fitting has been completed. The QAI was informed that the root will be welded from the bottom of the groove before additional weld will be deposited on the top side of the patch. See the attached photo.

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The QAI observed that ABF personnel are fitting the deck access hole patch at PP19.5-W5S. The QAI observed that the root faces of the patch and deck plate have been ground clean of cutting slag and appear to be conforming to the fit-up requirements of the WPS. The QAI noted that Kenneth Chappell, ID 3833, is using SMAW to make the fit-up / tack welds at this location. The QAI noted that the fit-up appeared to be conforming but has not been accepted by QC at the end of the shift.



Summary of Conversations:

The QAI had general conversations with ABF, QC and Caltrans personnel during this shift. As described above, the QAI had a conversation with the QC Inspector Steve McConnell regarding the fit up and root of the deck access hole patch at PP61.5-E2SE. The QAI relayed the observations of OBG splice welding to the QAI Danny Reyes. The QAI relayed the status of work observed to the Lead QAI Bill Levell. Except as described above, there were no other notable conversations during this shift.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Nina Choy (510)385-5910, who represents the Office of Structural Materials for your project.

Inspected By: Croff, Scott

Quality Assurance Inspector

Reviewed By: Levell, Bill

QA Reviewer